

Work Order ID 149591

Monday, July 25, 2016 2:37:40 PM

149591

Page 1

Item ID: D3204-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Release Pedal Assembly
Start Date: 8/3/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 8/17/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: AUG 02 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3204	Rev A1								
100	Large Fab	0.00							
100									
Large Fab	Memo	0.26							
Large Fab	1- Weld assembly as per Dwg D3204 using Jig D3204-041T1. 2- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld. 3- Use JB weld compound to plug the hole after assembly. 4- Grind JB weld flush after it is cured.								
110	QC9- Inspect visual per OSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									

2 @ 16-9-28② 16-09-28DAS
9
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS															
Part No. _____		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐									
NCR No. _____		Scrap ☐		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐									
		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐									
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☐											
Date : _____		Step #: _____		QTY Effective : _____				MRB (QSI042) Approval											
Description Work Order Deviation				Disposition															
								Completed By											
								Lead hand / Supervisor Approval Verification											
								QC / QA Coordinator Approval											
Root Cause				FAULT CATEGORY															
Environment ☐				Pressure/Forced ☐				Temperature/Cure ☐				Power Loss/Surge ☐				Positioned Wrong ☐			
Design ☐				Bending ☐				Set-up ☐				Folio/Program ☐				Outside Dimensions ☐			
Doc/Data ☐				Centre Not Concentric ☐				BOM/Route ☐				Grain ☐				Over/Under tolerance ☐			
Equip/Tooling ☐				Cracks ☐				Broken/Damage/Defect ☐				Weld ☐				Part Incorrect ☐			
Handling/Pre ☐				Crimp/Kink/Ripple/Wave ☐				Inspection Incomplete/Unqualified ☐				Wrong Stock Pulled ☐				Part Lost/Missing ☐			
Material ☐				Cuffs ☐				Contamination ☐				Out of Sequence ☐				Part Moved ☐			
Internal Transport ☐				Crushing ☐				Countersink ☐				Off-set ☐				Drawing ☐			
Tribal Knowledge ☐				Heat Treat ☐				Cut Too Short ☐				Mislabeled ☐				Finish ☐			
LOA ☐				Wave/Twist in Tube ☐				Instructions Incomplete/Unclear ☐				Fit/Function ☐				Misread ☐			
Substation ☐				Marks/Chatter ☐				Drill Holes ☐				Misaligned/off center ☐				Turning Sequence ☐			
Past Expiry Date ☐																			
Misidentified ☐																			
No Re-verification ☐																			
Operator ☐																			
Offset/Setup ☐																			
Supplier ☐																			
Training ☐																			
Use for Testing ☐																			
Poor Information ☐																			
Rushing ☐																			
Product Improvement ☐																			
Process Improvement ☐																			
Manufacturing Process ☐																			
Past Due ☐																			
				OTHER : _____															

Work Order ID 149591

Monday, July 25, 2016 2:37:40 PM

149591

Page 2

Item ID: D3204-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Release Pedal Assembly
Start Date: 8/3/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 8/17/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

120

QC

Quality Control

Memo

0.01

② 1609-28DAS
9
9-89

130	Chemical Conversion Coat per QSI005 4.1	0.00							
-----	---	------	--	--	--	--	--	--	--

130

HandFinish

Hand Finishing

Memo

0.05

②2016/09/28
BEB

140	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
-----	--	------	--	--	--	--	--	--	--

140

Powdercoat

Powder Coating

Memo

0.02

Cover holes for bushing

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:10.
300°
10:40.2 1609-28DAS
9
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																													
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																		
Large Fab ☐	Composite ☐	Supplier ☐																																																																			
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																														
Description Work Order Deviation				Disposition				Completed By																																																													
Root Cause				FAULT CATEGORY																																																																	
<table style="width: 100%; border: none;"> <tr><td>Environment ☐</td><td>No Re-verification ☐</td></tr> <tr><td>Design ☐</td><td>Operator ☐</td></tr> <tr><td>Doc/Data ☐</td><td>Offset/Setup ☐</td></tr> <tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td></tr> <tr><td>Handling/Pre ☐</td><td>Training ☐</td></tr> <tr><td>Material ☐</td><td>Use for Testing ☐</td></tr> <tr><td>Internal Transport ☐</td><td>Poor Information ☐</td></tr> <tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td></tr> <tr><td>LOA ☐</td><td>Product Improvement ☐</td></tr> <tr><td>Substation ☐</td><td>Process Improvement ☐</td></tr> <tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td></tr> <tr><td>Misidentified ☐</td><td>Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	<table style="width: 100%; border: none;"> <tr><td>Pressure/Forced ☐</td><td>Temperature/Cure ☐</td></tr> <tr><td>Bending ☐</td><td>Set-up ☐</td></tr> <tr><td>Centre Not Concentric ☐</td><td>BOM/Route ☐</td></tr> <tr><td>Cracks ☐</td><td>Broken/Damage/Defect ☐</td></tr> <tr><td>Crimp/Kink/Ripple/Wave ☐</td><td>Inspection Incomplete/Unqualified ☐</td></tr> <tr><td>Cuffs ☐</td><td>Contamination ☐</td></tr> <tr><td>Crushing ☐</td><td>Countersink ☐</td></tr> <tr><td>Heat Treat ☐</td><td>Cut Too Short ☐</td></tr> <tr><td>Wave/Twist in Tube ☐</td><td>Instructions Incomplete/Unclear ☐</td></tr> <tr><td>Marks/Chatter ☐</td><td>Drill Holes ☐</td></tr> </table>		Pressure/Forced ☐	Temperature/Cure ☐	Bending ☐	Set-up ☐	Centre Not Concentric ☐	BOM/Route ☐	Cracks ☐	Broken/Damage/Defect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Cuffs ☐	Contamination ☐	Crushing ☐	Countersink ☐	Heat Treat ☐	Cut Too Short ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Marks/Chatter ☐	Drill Holes ☐	<table style="width: 100%; border: none;"> <tr><td>Power Loss/Surge ☐</td><td>Positioned Wrong ☐</td></tr> <tr><td>Folio/Program ☐</td><td>Outside Dimensions ☐</td></tr> <tr><td>Grain ☐</td><td>Over/Under tolerance ☐</td></tr> <tr><td>Weld ☐</td><td>Part Incorrect ☐</td></tr> <tr><td>Wrong Stock Pulled ☐</td><td>Part Lost/Missing ☐</td></tr> <tr><td>Out of Sequence ☐</td><td>Part Moved ☐</td></tr> <tr><td>Off-set ☐</td><td>Drawing ☐</td></tr> <tr><td>Mislabeled ☐</td><td>Finish ☐</td></tr> <tr><td>Fit/Function ☐</td><td>Misread ☐</td></tr> <tr><td>Misaligned/off center ☐</td><td>Turning Sequence ☐</td></tr> </table>		Power Loss/Surge ☐	Positioned Wrong ☐	Folio/Program ☐	Outside Dimensions ☐	Grain ☐	Over/Under tolerance ☐	Weld ☐	Part Incorrect ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Out of Sequence ☐	Part Moved ☐	Off-set ☐	Drawing ☐	Mislabeled ☐	Finish ☐	Fit/Function ☐	Misread ☐	Misaligned/off center ☐	Turning Sequence ☐
Environment ☐	No Re-verification ☐																																																																				
Design ☐	Operator ☐																																																																				
Doc/Data ☐	Offset/Setup ☐																																																																				
Equip/Tooling ☐	Supplier ☐																																																																				
Handling/Pre ☐	Training ☐																																																																				
Material ☐	Use for Testing ☐																																																																				
Internal Transport ☐	Poor Information ☐																																																																				
Tribal Knowledge ☐	Rushing ☐																																																																				
LOA ☐	Product Improvement ☐																																																																				
Substation ☐	Process Improvement ☐																																																																				
Past Expiry Date ☐	Manufacturing Process ☐																																																																				
Misidentified ☐	Past Due ☐																																																																				
Pressure/Forced ☐	Temperature/Cure ☐																																																																				
Bending ☐	Set-up ☐																																																																				
Centre Not Concentric ☐	BOM/Route ☐																																																																				
Cracks ☐	Broken/Damage/Defect ☐																																																																				
Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐																																																																				
Cuffs ☐	Contamination ☐																																																																				
Crushing ☐	Countersink ☐																																																																				
Heat Treat ☐	Cut Too Short ☐																																																																				
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐																																																																				
Marks/Chatter ☐	Drill Holes ☐																																																																				
Power Loss/Surge ☐	Positioned Wrong ☐																																																																				
Folio/Program ☐	Outside Dimensions ☐																																																																				
Grain ☐	Over/Under tolerance ☐																																																																				
Weld ☐	Part Incorrect ☐																																																																				
Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																				
Out of Sequence ☐	Part Moved ☐																																																																				
Off-set ☐	Drawing ☐																																																																				
Mislabeled ☐	Finish ☐																																																																				
Fit/Function ☐	Misread ☐																																																																				
Misaligned/off center ☐	Turning Sequence ☐																																																																				
OTHER :																																																																					

Monday, July 25, 2016 2:37:40 PM

Page 3

Stop *NS2*

Customer:

Stop ***NR2***

Quality Control

2x 16/09/28 DAS 36 9-89

2x 16/09/28

38
9-89

SEP 28 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 149591

Monday, July 25, 2016 2:37:40 PM

149591

Page 4

Item ID: D3204-041**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Release Pedal Assembly**Start Date:** 8/3/2016 **Start Qty:** 2.00 ***2*****Cust Item ID:****Required Date:** 8/17/2016 **Req'd Qty:** 2.00 ***2*****Customer:****Reference:****Approvals:****Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run Start *NR1*****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop *NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

180

Identify as per dwg & Stock Location: _____

0.00

180

Packaging

Packaging

Memo

LOCATION : GA

0.00

2
DAS
6
9-89

SEP 2 8 2016

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Quality Control

Memo

0.03

DAS
21
9-89

SEP 3 0 2016

DAS
21
9-89

SEP 2 8 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Monday, July 25, 2016 2:37:39 PM

Page 1

Work Order ID: 149591

149591

Parent Item: D3204-041

D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 8/3/2016

Required Date: 8/17/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: C05.08.11Added Step 25 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3204-1 *D3204-1* Tube		Manufactured	No			100	Each	22.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA002				22					
				144635				22					
D3204-11 *D3204-11* Plate		Manufactured	No			100	Each	14.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA002				14					
				141528				1					
				142724				13					
D3204-13 *D3204-13* Gusset		Manufactured	No			100	Each	27.0000	2	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA002				27					
				136371				17					
				148611				10					
D3204-3 *D3204-3* Arm		Manufactured	No			100	Each	13.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA001				12					
				145631				12					
				WA002				1					
				144602				1					

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Monday, July 25, 2016 2:37:39 PM

Page 2

Work Order ID: 149591

149591

Parent Item: D3204-041

D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 8/3/2016

Required Date: 8/17/2016

Start Qty: 2.00

Required Qty: 2.00

D3204-5

Manufactured No

100

Each

10.0000

1

2

D3204-5

Arm

EL 16-9-27

Location

Loc Qty

Loc Code

148254
x2

WA002

10

144600

10

D3204-7

Manufactured No

160

Each

37.0000

2

4

D3204-7

Bushing

16/09/28 **DAS 36 9-89**

Location

Loc Qty

Loc Code

GA

37

147440

37

D3204-9

Manufactured No

100

Each

11.0000

1

2

D3204-9

Pedal

EL 16-9-27

Location

Loc Qty

Loc Code

WA002

11

142457

1

144594

10

Monday, July 25, 2016 2:37:39 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

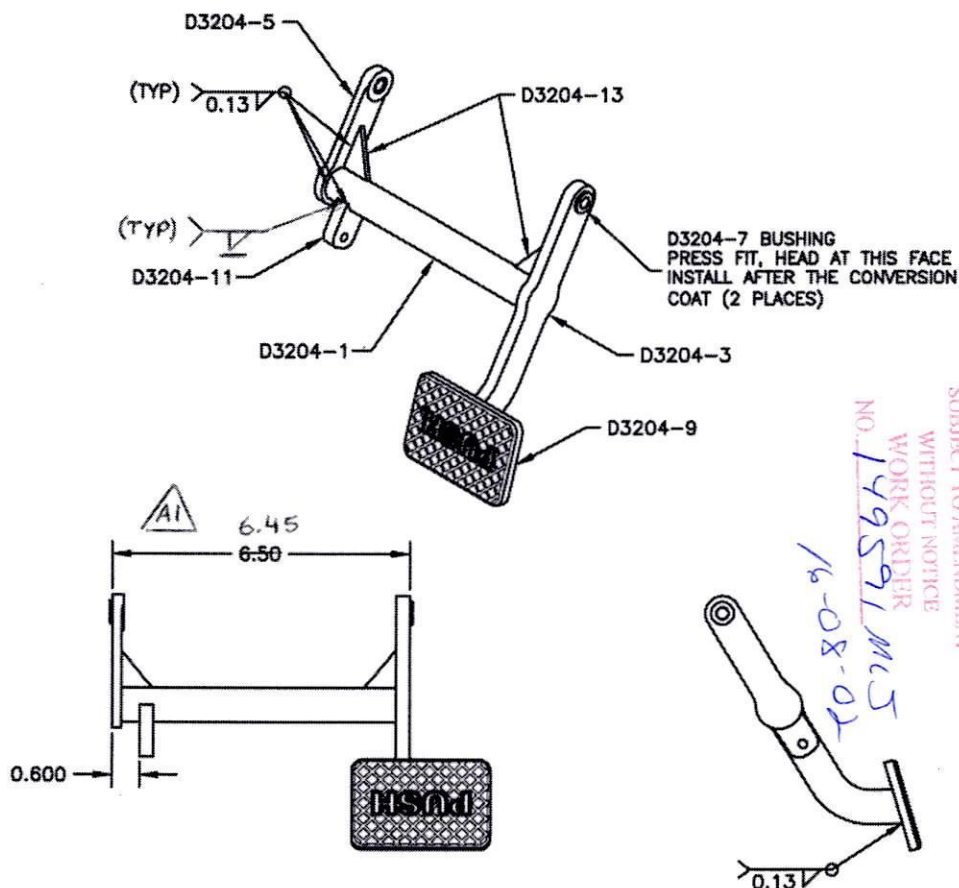
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : _____			

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
AI	05.07.15	6.45 WAS 6.50	

RELEASED
04.04.30



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.